

Work Order ID 59370

June 2, 2010 1:14:03 PM



Page 1

Item ID:	D2601-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Console Side, 206 Console					
Start Date:	6/02/10	Start Qty:	8.00		Cust Item ID:	
Required Date:	6/02/10	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2601	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2601 Deburr if necessary		<input checked="" type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-				

B 10-6-2

⑧

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-6-2

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

S.066603

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

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00000000000000000000000000000000

**Cust Item ID:**

Customer:

Run Start

Stop



**Insp.
Stamp**

0.00

NC BRAKE

0.00

Brake NC

Memò

Brake NC

1-deburr if necessary□2-Form as per Dwg D2601

140

0.00

[REDACTED]

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

150

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

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Work Order ID 59370

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Item ID: D2601-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Console Side, 206 Console

Start Date: 6/02/10 Start Qty: 8.00



Cust Item ID:

Required Date: 6/02/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		99 16/06/07		5	0		
170 Packaging Packaging	Identify as per dwg & Stock Location: 178 Memo	0.00 0.00				(X8)	BB	10/06/09	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						10/06/09	

MF 10-6-9

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59370



Parent Item: D2601-1



Parent Item Name: Console Side, 206 Console

Start Date: 6/02/10

Required Date: 6/02/10

Comments: IPP C 98.11.25 Added Inspection Levels DM

Start Qty: 8.00

Required Qty: 8.00

Note: Issue with part number D2601-2

IPP Rev:D 07-12-18 now waterjet ECN1059 DD verified by: EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M2024T3S.040		Purchased	No			100	sf	479.9000	1.3472	11.34484			



2024-T3 .040 sheet



H310-6-2

Location

Loc Qty

Loc Code

MAT

96

114415

96

MAT22

383.9

110305

131.1

111786

15.5

112291

32

112331

64

113162

141.3

112331

8

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59370
Description: Console Side LH		Part Number:	D2601-1
Inspection Dwg: D2601	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.098	✓			
13.00	+/-0.030	13.00	✓			
1.35	+/-0.030	1.348	✓			
1.375	+/-0.010	1.375	✓			
0.300	+/-0.010	.298	✓			
6.000	+/-0.010	5.997	✓			
9.45	+/-0.030	9.45	✓			
10.90	+/-0.030	10.90	✓			
8.875	+/-0.010	8.872	✓			
0.340	+/-0.010	.340	✓			
0.500	+/-0.010	.504	✓			
0.878	+/-0.010	.876	✓			
1.254	+/-0.010	1.248	✓			
2.47	+/-0.030	2.481	✓			
0.92	+/-0.030	.916	✓			
11.239	+/-0.010	11.237	✓			
10.70	+/-0.030	10.700	✓			
13.75	+/-0.030	13.75	✓			
14.18	+/-0.030	14.18	✓			
0.838	+/-0.010	.835	✓			
2.648	+/-0.010	2.641	✓			
0.040	+/-0.010	.039	✓			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-2	Date:	10/06/03	Date:	

Rev	Date	Change	Revised by	Approved
A	09.03.10	New Issue	KJ/DD	DD

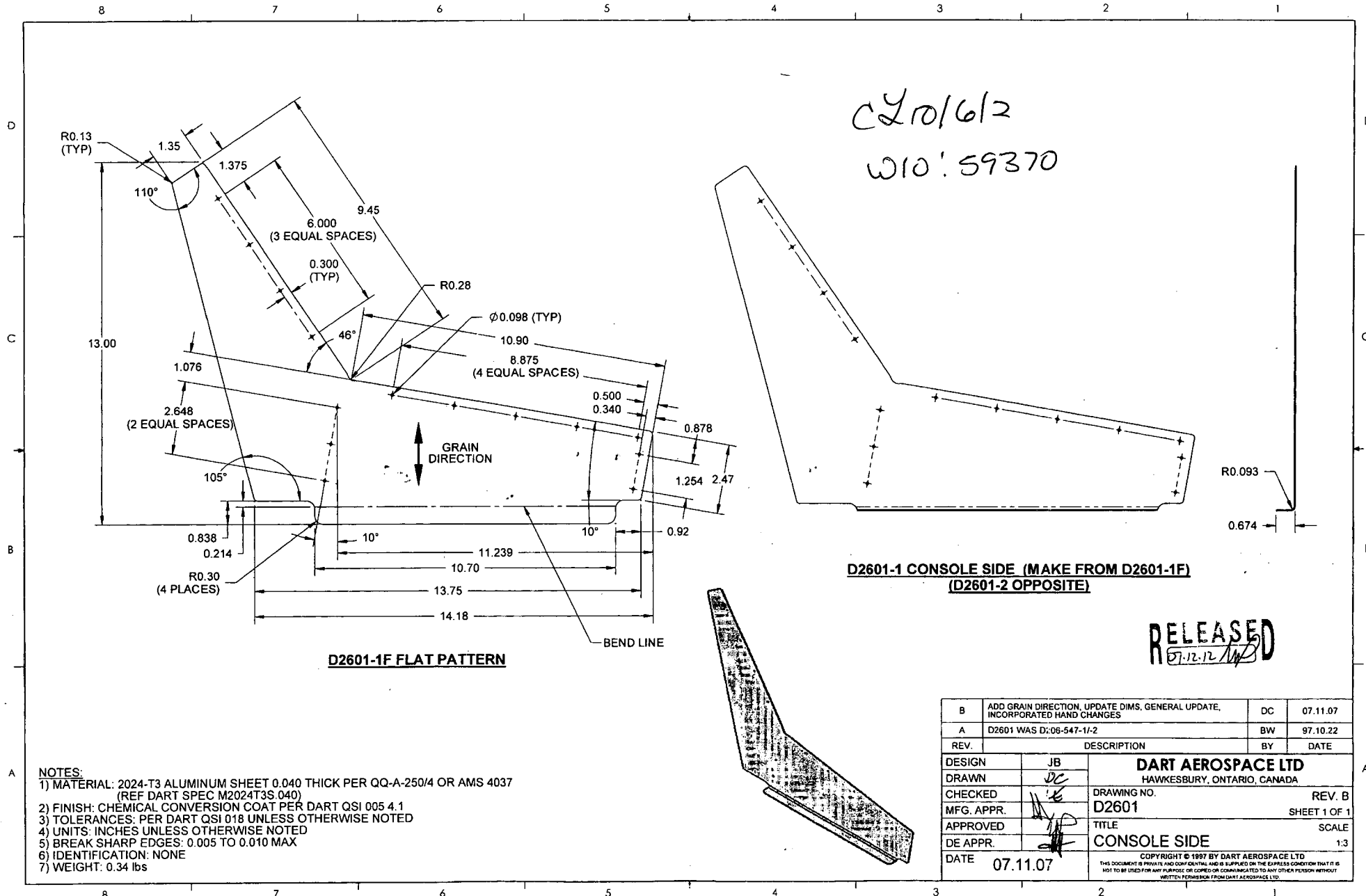
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B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2601 WAS D:06-547-1A-2	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.		D2601	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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